

Work Order ID 70041

Wednesday, May 25, 2011 1:03:57 PM

Page 1



Item ID: D3371-3

Accept



Setup Start



Revision ID:

Item Name: Pedal Lock Cover

Stop



Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/05/05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date: 1

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan- Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3371	Rev B								
100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 2.00" x 2.25" x 7.370" long								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine D3371-3 as per Folio FA486 and Dwg D3371 2-Deburr 3-Finish 8-32 thread by hand Identify as D3371-3								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

OK 11/07/07

4

2 11.7.15

4

2 11.7.15

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3371-3 PAR #: _____ Fault Category: Machining / Programming NCR: Yes No DQA: Ch Date: 11/07/20
 Resolution: GOOD AS IS Disposition: GOOD AS IS QA: N/C Closed: JS Date: 11-07-20

NCR: <u>D3371-3</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11.7.18</u>	<u>110</u>	<u>Third operation of axis position off by .045" in program</u> <u>R.C. PROGRAM NOT UPDATED.</u>	<u>11.07.18</u>	<u>Corrected in network</u> <u>ACCEPTABLE AS IS. FIX</u> <u>AS REQ'D AT ASSY.</u>	<u>11.7.18</u>	<u>W07/18</u>	<u>11.07.18</u>	<u>W07/18</u>

NOTE: Date & initial all entries

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Item ID:	D3371-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Pedal Lock Cover					
Start Date:	5/25/2011	Start Qty:	4.00			
Required Date:	6/10/2011	Req'd Qty:	4.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	11-07-18		(H)			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							4 of 11-07-19
145 Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3 M10239L Memo ***cover inside holes prior painting*** Start Time: 8:20 Oven Temperature: 320° Finish Time: 8:50	0.00 0.00							4 of 11-7-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70041

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Item ID: D3371-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Cover

Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4	0	11/07/19	
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00	SB	11/07/19		(4)			
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/17/20	ME 11-07-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 70041



Parent Item: D3371-3



Parent Item Name: Pedal Lock Cover

Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A□05.01.18□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.25 0		Purchased	No			--100	f	0.0000	0.625	2.631579			



6061-T6 Bar 2.00 x 2.25



M118072 X 2.64"

am 11/07/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	70041
Description: Pedal Lock Cover		Part Number:	D3371-3
Inspection Dwg: D3371 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.450	+/-0.005	1.450	✓		Re. 02	
7°	+/-0.5°	7°	✓		"	
0.104	+/-0.010	.110	✓			
0.305	+/-0.010	.347	✓			
1.650	+/-0.010	1.650	✓			
1.30	+/-0.030	1.297	✓			
Ø1.000	+/-0.010	.999	✓			
45°	+/-0.5°	45°	✓			
Ø1.300	+/-0.010	1.300	✓			
0.500	+/-0.010	.497	✓			
60°	+/-0.5°	60°	✓			
2.25	+/-0.030	2.250	✓			
1.650	+/-0.010	1.650	✓			
3.950	+/-0.010	3.954	✓			
1.330	+/-0.005	1.330	✓		"	
7.19	+/-0.030	7.200	✓			
4.500	+/-0.010	4.502	✓			
0.635	+0.010/-0.000	.635	✓			
1.125	+/-0.010	1.125	✓			
0.750	+/-0.010	.750	✓			
Ø0.750	+0.010/-0.000	.759	✓			
3.625	+/-0.010	3.631	✓			
Ø1.200	+/-0.010	1.198	✓			
0.750 deep	+/-0.010	.753	✓			
0.500	+/-0.010	.501	✓			
2.00	+/-0.030	2.000	✓			
1.000	+/-0.010	1.000	✓			
0.375	+/-0.010	.375	✓			
Ø0.185	+0.005/-0.000	.185	✓			
0.400 deep	+/-0.010	.400	✓		"	

Measured by:	Re
Date:	11-7-15

Audited by:	SL
Date:	11-07-18

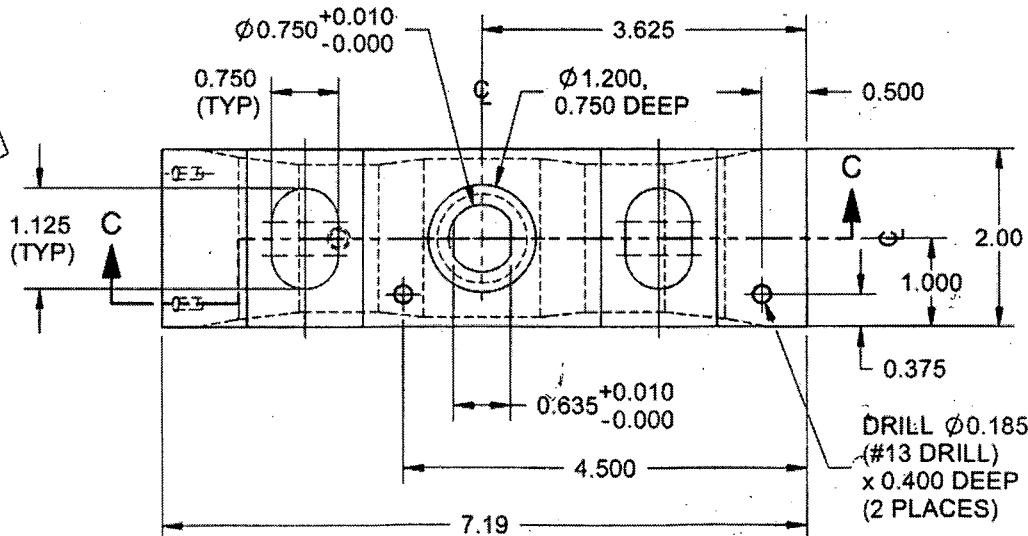
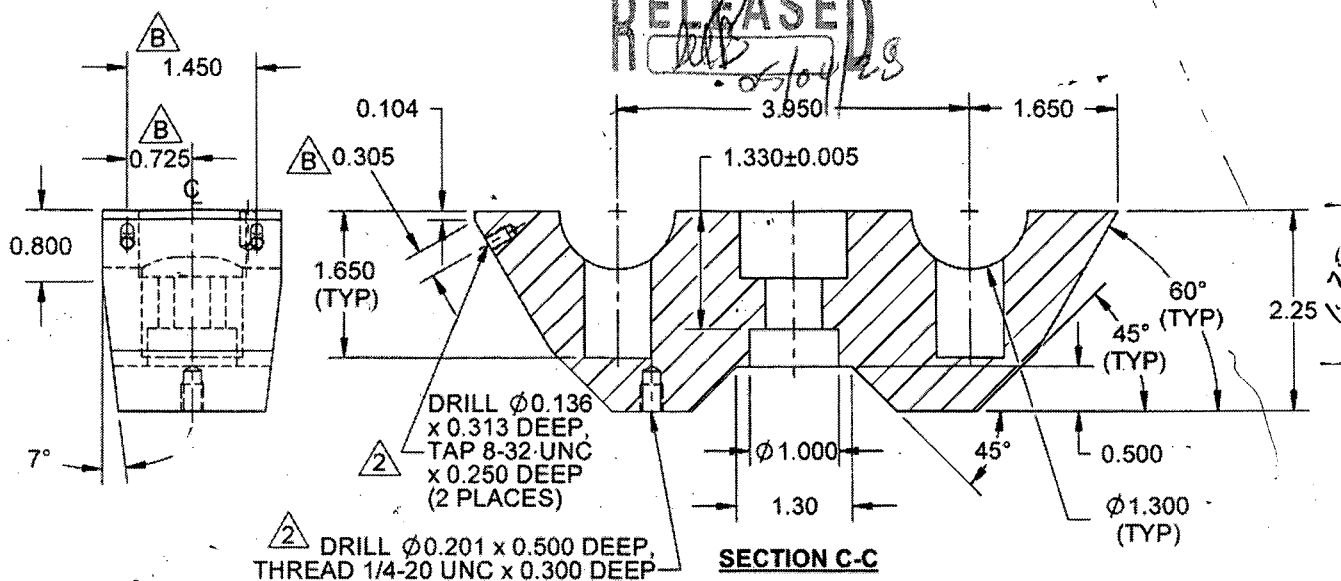
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Revised dimensions	KJ/JLM	

[Handwritten scribbles]



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CL11/05/25
WRO: 70041